

Work Order ID 115215

115215

Page 1

March-18-14 10:51:27 AM

Item ID: D412-824-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube Step Fits LH or RH

Start Date: 3/18/14 Start Qty: 2.00

2

Cust Item ID:

Required Date: 4/01/14 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-03-18 Tooling:

Date:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

DSI 9664

A

IIN-D412-824

A

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D412-824-011 CHG002

DAS
31
9-89

14-03-21

2x

MLJ 14-03-20

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

DAS
28
9-89

2x

14-03-21

Work Order ID 115215

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Page 2

Item ID: D412-824-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube Step Fits LH or RH

Start Date: 3/18/14 Start Qty: 2.00

2

Cust Item ID:

Required Date: 4/01/14 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____ Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS
31
9-89

14-03-21

2x

MAR 21 2014

130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-824-011
Location: 042

DAS
06
9-89

2x

MAR 21 2014

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MCS 14-03-21

14-03-21

Picklist Print

March-18-14 10:51:30 AM

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Work Order ID: 115215

115215

Parent Item: D412-824-011

D412-824-011

Parent Item Name: Skidtube Step Fits LH or RH

Start Date: 3/18/14

Required Date: 4/01/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.10.02 PER DWG REVA DD VERF:JFS IPP
REV:B 13.11.01 as per chg002 ecn13-649 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4630-041		Manufactured	No				Each	0.0000					
2x *D4630-041*													
Skidtube Step Assembly													

** 113262 DAS 06 9-99 ND

DAS
31
9-99

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-824 Rev. A

REF. TCCA STC: SH96-88
REF. FAA STC: SR00563NY
REF. EASA STC: EASA.IM.R.S.01303
REF. JAPANESE STC: STC-55-1-TYO

1.0 PURPOSE:

The purpose of this Dart Service Instruction is to provide customers with D412-824-011 step at change 001 with instructions to mount the step on skid tubes with narrow ground handling lug configuration. On D412-824-011 step at change 002 and subsequent, the D4630-1 cover has been modified to include two additional mounting holes to accommodate both narrow and wide lug configurations.

2.0 PARTS LIST:

There is no change to the parts list.

3.0 WEIGHT AND BALANCE:

There is a negligible weight and balance change associated with this modification.

4.0 PROCEDURE:

- 4.1 Remove skid tube step per section 3.2 of IIN-D412-824.
- 4.2 Place skid tube step on suitable working surface and remove D4630-3 center mounting bracket and associated hardware from D4630-1 cover.
- 4.3 Drill two $\varnothing 0.266$ holes through the cover and countersink $\varnothing 0.53$ at 100° as per Figure 1 of this service instruction. Deburr holes to remove all sharp edges and touch up hole with Alodine 1200/1201 per MIL-C-5541.
- 4.4 Reinstall D4630-3 center mount into new holes using existing hardware and torque to 50-70 in-lbs.
- 4.5 Reinstall skid tube step per section 3.1 of IIN-D412-824.

5.0 INSTALLATION CHANGES

Changes to IIN-D412-824 Installation / Removal procedures are as follows:

IS

- 3.1.1 Ensure the middle D4630-3 step mount is installed in the correct hole position in reference to the skid tube ground handling lug configuration. The step is shipped with the middle D4630-3 bracket installed for the wide ground handling lug spacing. To re-configure to the narrow ground handling lug spacing, remove D4630-3 bracket and re-install in the other set of holes. Torque bolts to 50-70 in-lbs.

WAS

- 3.1.1 Ensure Ground Handling Lugs are installed to give wide lug spacing.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO #01-O-01

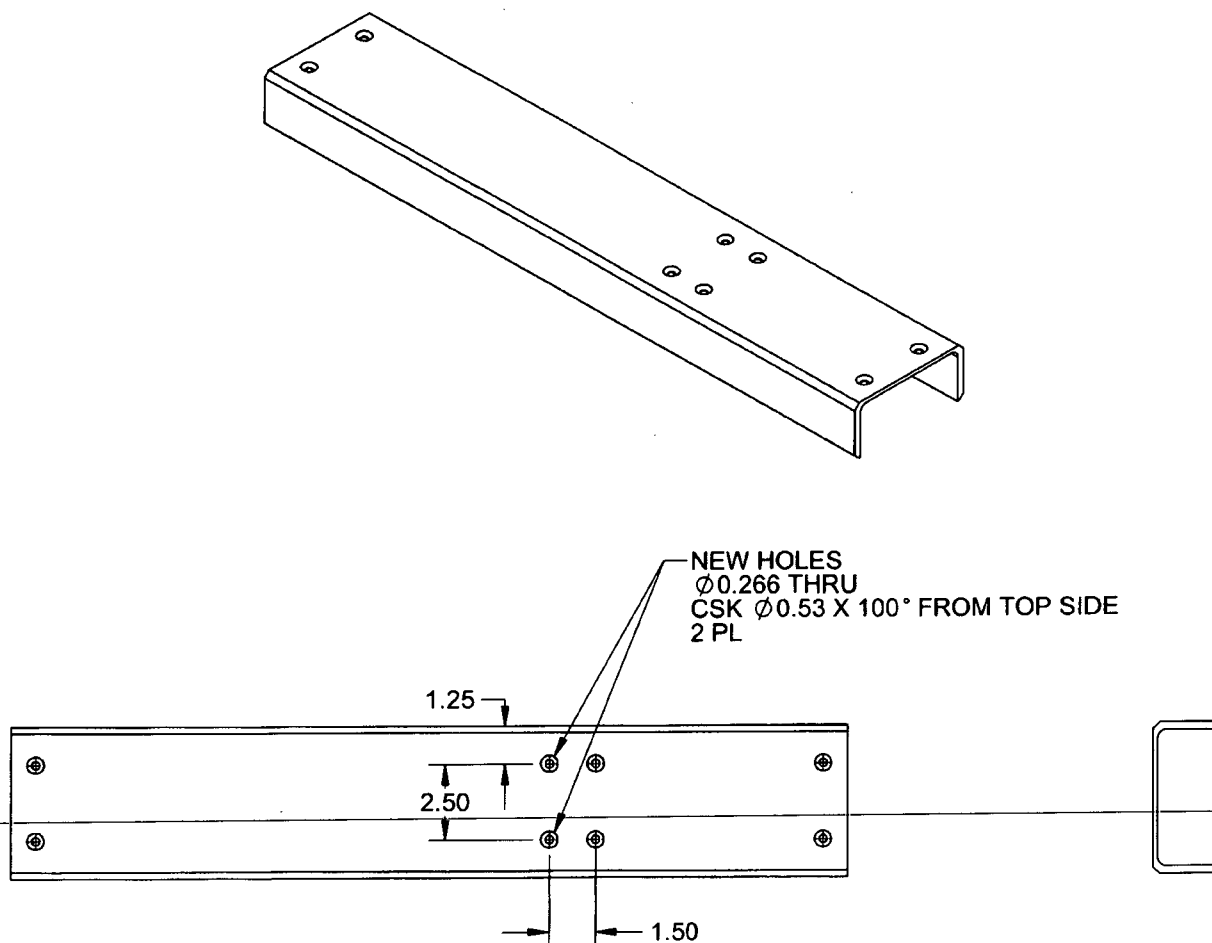
APPROVED

BY: [Signature]
D. SHEPHERD (DE #02)

DATE: 13.10.30
CERT. NO.: SH96-88
ISSUE NO.: 1

A	NEW ISSUE	ML	13.10.28
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FIGURE 1.
REFERENCE FOR DRILLING NEW HOLES IN COVER D4630-1



CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 13.10.30
CERT. NO.: SH96-88
ISSUE NO.: 1

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4.0 PARTS LIST

-011	Part Number	Description
X	D412-824-011	SKIDTUBE STEP
1	D4630-041	SKIDTUBE STEP ASSY

5.0 WEIGHT AND BALANCE

Installation	Weight	Longitudinal		Lateral	
		Arm	Moment	Arm	Moment
D412-824-011 ON LOW NARROW GEAR	5.90 lb 2.68 kg	144.5 in 3.67 m	853 in-lb 9.84 m-kg	±47 in ±1.19 m	±277 in-lb ±3.19 m-kg
D412-824-011 ON STANDARD GEAR	5.90 lb 2.68 kg	144.5 in 3.67 m	853 in-lb 9.84 m-kg	±50.0 in ±1.27 m	±295 in-lb ±3.40 m-kg
D412-824-011 ON HIGH GEAR	5.90 lb 2.68 kg	144.5 in 3.67 m	853 in-lb 9.84 m-kg	±55.0 in ±1.40 m	±324 in-lb ±3.74 m-kg
D412-824-011 ON 31" GEAR	5.90 lb 2.68 kg	144.5 in 3.67 m	853 in-lb 9.84 m-kg	±54.0 in ±1.37 m	±318 in-lb ±3.67 m-kg
D412-824-011 ON 39" GEAR	5.90 lb 2.68 kg	144.5 in 3.67 m	853 in-lb 9.84 m-kg	±60.0 in ±1.52 m	±354 in-lb ±4.08 m-kg